



Dart Aerospace Ltd.
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5083534

D4379-1
Job Sheet 177201



Part No: **D4379-1**

Job Qty: 50 ea

Part Name: Wearplate Cup



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/8/18

Job Tracking No:

Due Date: 6/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 1 IPP REV:A NEW ISSUE 11-04-13 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier Lead Time	
90	Start up Operation	50 Ea		6/18/18	0.00	0.00	Start Up Machining-3	<i>MRP 18/06/24</i>
100	Doosan	50 pcs		6/18/18	0.00	6.39	Doosan	<i>MRP 18/06/24</i>
120	QC	50 pcs		6/18/18	0.00	0.00	QC8	<i>MRP 18/06/25</i>
130	Packaging	50 pcs		6/18/18	0.00	0.00	Packaging3-2	<i>Q</i>
140	QC21-SA	50 Ea		6/18/18	0.00	0.00	QC21	<i>DAG 21 JUN 25 2018</i>

Part Op 100 - turn as per Dwg and folio FB057
Descriptions: 130 - LOCATION: WA002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304RO.750	304 SS Roundbar .750	2.5000 ft (.05 ea)	90-Start up Operation	<i>5033397</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304RO.750	3	61	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.266Inches + 0.006 - 0.001	<i>0.270</i> 0.272 0.265	Diameter	
2	Wearplate	0.507Inches ± 0.010	<i>0.501</i> 0.517 0.497		
3	Wearplate	0.233Inches ± 0.010	<i>0.231</i> 0.243 0.223		
4	Wearplate	0.466Inches ± 0.010	<i>0.464</i> 0.476 0.456		
5	Wearplate	0.625Inches + 0.000 - 0.005	<i>0.622</i> 0.625 0.620		
6	Wearplate	0.200Inches ± 0.010	<i>0.201</i> 0.210 0.190		
7	Wearplate	0.438Inches ± 0.010	<i>0.438</i> 0.448 0.428		
8	Wearplate	0.030Inches ± 0.100	<i>0.030</i> 0.130		

		(0.070)			
9	Wearplate	45°	45.000Degrees ± 0.000	45.000	Angle
				45.000	

Plex 5/8/18 10:43 AM Dart.lajeunesse.marie



WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only

Work Order:		DISPOSITION		AGAINST DEPARTMENT/PROCESS						MRB (QS1042) Approval	
Part No.:		Suspected Unapproved		Skid-tube		Cross tube		Water Jet		Engineering	
NCR No.:		Rework		Machining		Small Fab		Prod. Eng. Coord.		Quality	
Date:		Use-as-is		Thermoforming		Finishing		Rec/Store/Packaging		Other	
Step #:		Suspected Unapproved		Large Fab		Composite		Supplier			
Description Work Order Deviation		Disposition									
QTY Effective :											
Completed By											
Lead hand / Supervisor											
Approval Verification											
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/W Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter OTHER :											

Container No: S083535

Part: D4379 - 1
Job No: 177201
Serial No/Batch: S083535
Revision:
Inspector:
Exp Date:
Instructions:

Date: 06/24/18

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